

Date: Wednesday, 6/27/2007 1:08:12 PM
 User: Kim Johnston

Process Sheet

(S)

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CROSSBOLT SPACER		
Job Number	: 33214					
Estimate Number	: 11010					
P.O. Number	: N/A		Part Number	: D2649		
This Issue	: 6/27/2007	S.O. No. : N/A	Drawing Number	: D2649 REV B1		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A	Type : MACHINED PARTS	Drawing Revision	: B1		
Previous Run	: 31926		Material	: N/A		
Written By	:		Due Date	: 7/25/2007	Qty:	1,000 Um: Each
Checked & Approved By	:	2007.06.28				
Comment	: Est F 02.03.26 Added turning on Cobra NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W	 <i>20 07/07/07 104997 1</i> <i>Batch M105042 (84) 24</i>
		Comment: Qty.: 0.2975 f(s)/Unit Total : 297.4650 f(s) 6061-T6 Tube .375 x.058W Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	 <i>20 07/07/07 88</i>
		Comment: HARDINGE CNC LATHE SMALL Machine as per folio _____ on cobra machine.	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>20 07/07/07 85 1003</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	 <i>20 07/07/07 85 1003</i>
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>BARCLAY</i>	<i>20 07/07/07 1000</i>
6.0	QC21	FINAL INSPECTION/W/O RELEASE	 <i>20 07/07/07 1000</i>
		Comment: FINAL INSPECTION/W/O RELEASE	<i>20 07/07/07 1000</i>
		Job Completion	 <i>20 07/07/07 30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33214
Description: Crossbolt Spacer	Part Number:	D2649
Inspection Dwg: D2649	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

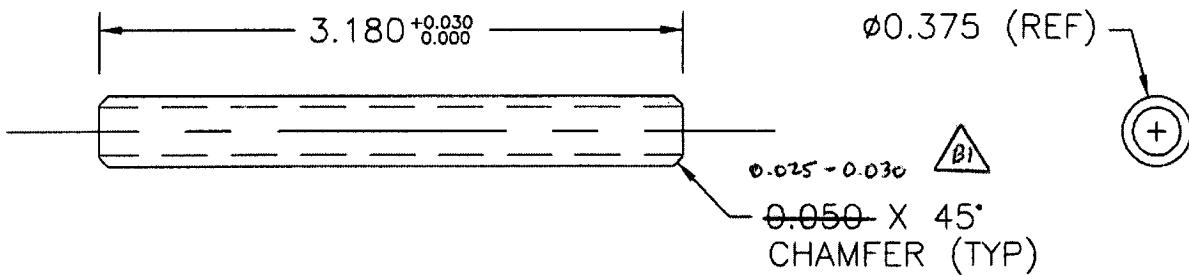
Measured by:	RQ / SF	Audited by:	J.F.	Prototype Approval:	N/A
Date:	09/07/21	Date:	07/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF <i>✓</i>	<i>TT</i>

DART

DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1

A	97.03.25	NEW ISSUE
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER
B1	# CP 02.06.13	REDUCE CHAMFER PER TSR 1296.

RELEASED
98.01.20 DS


MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
 0.375 DIA 0.058 WALL
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE

SHOP COPY
 RETAIN
 ENGINEERING
 QSI
 LED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 33214